	Work Order ID 89123  ugust-21-12 2:47:30 PM  D350-607-541			*89 <i>*</i>	123*						Page 1
Item ID: Revision ID:	D350-607-54			Accept	*N900	040	100	)* s	Setup Sta	rt *N	S1*
Item Name:	Heli-Utility-Ba	sket 🚗							Sto	<sup>p</sup> *N	S2*
	्रि 8/27/12	Start Qty: 1.	00 *1*		Cust Item 1	ID:					
Required Date: 9	9/1 <u>4/</u> 12	Req'd Qty: 1.	•		Customer:						
Reference:	2.00	•	•								
Approvals:	Process Plan	1: <u>M</u> LJ	Date: 12 08	22 Tooling:	D	ate:		F	Run Sta	1/1	R1*
ż			Date:		D	ate:			Sto	<sup>)p</sup> *N	R2*
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revi	sion Nbr									
D350-607-3	A										
*100*		DOCUMENT CO	NTROL	0.00	is wolle			4	401	MLJ	12-10-1
DC		Memo		0.00	E. Coople	1.1			) ———		
Document Control		Photo	copy bluefile & type labels p	0.00 0.00 per PPPD350-607-541 C共 <b>9</b>							
110		Pick Kit		0.00					//	1	
*110*										4418	· ·
Packaging		Memo		0.00						11918	T THE PARTY NAME AND ADDRESS OF THE
Packaging			Mask label plate to size of De irea for label, apply label***	4086 label, use scotchbrite r *	ed pad to lightly				ŕ		
120		QC4- 100% Inspec	et kits for completeness	0.00							
*120* QC Quality Control		Memo		0.00 ( 16.	Mole			(40)	)	···	

NCR:	Yes / 1	lo			<b>WORK ORDER NON-</b>	CO	NFOR	MANCE / UPI	DATE		** **	>
								· _		QA Closed:	Date:	
Work Ord	er:				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	•
					Rework	7		Skid-tube	Crosstube	]	Water Jet	Engineering
Part	No.				Scrap	1	E .	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is	1	Thern	noforming	Finishing	-1	re/Packaging	Other
NCR	No				Work Order Update	]		Large Fab	Composite	]	Supplier	
Root				Descri	Iption of work order update	T	Initial	Act	ion	Sign &		
Cause	Da	e Ster	Qty		or Non-conformance	Cł	nief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator	Ш											
Material											:	
Setup												
Other	Ш											
Process	Ш											
Supplier	Ш											
Training	Ш						a.					
Unapproved						1						<u> </u>
				<del></del>	F.	AUI	LT CATE	GORY				
Landi	ng Gear			_	General		7		_	<b>-</b> 1	_	7
	Bendi	_			Bend		Grain			Ovalized		Pressure/Forced
	Centr	Not Conc	entric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Crack	i			Broken/Damaged		Inspecti	on Incomplete		Part Incorred	ct	Weld
	$\vdash$	ed/Crimpe	d.		Burrs	L	Instruct	ions Incomplete/U	Inclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte		ļ	Part Moved		
	Heat <sup>-</sup>	reat			Countersink		Mislabe	led		Positioned V	Vrong	7
	Inspection Strip in Tube				Cut Too Short	L	Misread	l		Power Loss/	Surge	Other
	Ripple	s in Bend		1	Drill Holes	1	Offset					

Out of Calibration

Outside Dimensions

Out of Sequence

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio

0.00

Memo

**Quality Control** 

W12-10.19

NCR:	Yes / N	o			WORK ORDER NON-	COI	NFOR	MANCE / UPDATE				•
	-							_		QA Closed:	Date	e: <u> </u>
Work Ord	er:				DISPOSITION					PARTMENT	_	•
Part I					Rework Scrap Use-as-is Work Order Update		1	Skid-tube Crosstub Machining Small Fa noforming Finishir Large Fab Composit	ıb ng	-1	Water Jet J. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root				Descri	tion of work order update		Initial	Action		Sign &		
Cause	Dat	e Step	Qty	(	or Non-conformance	Ct	nief Eng	Description		Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved												
11*						AUL	T CATE	GORY				
Landi	Cracks Crushe Cuffs Heat T Inspec	Not Conc d/Crimpe reat tion Strip is	d. n Tube		General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Instruct Mainte Mislabe Misreac Offset	on Incomplete ions Incomplete/Unclear nance led		Ovalized Over/Under Part Incorred Part Lost/Mid Part Moved Positioned W Power Loss/S	t ssing	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
į	rorque	Waves in	EXTRUSIO	n [	Drawing	1	Jour or C	alipration				

Out of Calibration Out of Sequence

Outside Dimensions

Date: \_\_

Turning Sequence

Wave/Twist in Tube

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

## ← Picklist Print

August-21-12 2:47:29 PM

Work Order ID:

89123

Parent Item:

D350-607-541

Parent Item Name:

Heli-Utility-Basket

**Start Date: 8/27/12** 

Required Date: 9/14/12

Start Qty: 1.00

Required Qty: 1.00

**Comments:** 

IPP REV:A 10-08-19 AS PER REV.A DD VERF BY:EC label DD verf by:EC

IPP Rev:B 11.02.09 add to install

IPP REV:C 12.03.06 AS PER ECN12-535 DD VERF:EC

Component Item ID/ tem Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
350-607-511 CHC70	ധ്യ unting Installation	Manufactured	No			110	Each	2.0000		1	8711	'6 C	1
				Location		Loc Qty	<u>L</u>	oc Code					
				FG		2							
				857	48	2							_
2690-6 Inyard Assembly		Manufactured	No			110	Each	28.0000		1	89 3	7/	/
				<b>Location</b>		Loc Oty	<u>L</u>	oc Code					
				ST014		10							
				885	53	10							
				ST017		18						1	
				8693	26	18	F 1	1 0000					
3912:041 yebolt Receiver Assembl	у	Manufactured	No			110	Each	1.0000		<u>l</u>			ک ⁄
				Location		Loc Qty	<u>L</u>	oc Code					,
				ST096		1				<del>77</del> /-			
				870	76	1			- <del> </del>	1076			
4030-041		Manufactured	No			110	Each	0.0000	0	1	8831	13/	- H
ong Basket Assembly (35	50)		N1.			110	r:1-	22 0000		· · · · · · · · · · · · · · · · · · ·	~	-97	
4085-3 lacard, Instructions		Manufactured	No			110	Each	32.0000		<u>l</u>			<u>/ S</u>
				<b>Location</b>		Loc Qty	<u>L</u>	oc Code					
				ST092		8			Market .				
				870	37	8							
				ST095		24				<del>7 72</del> 8	>		
				877	38	24			4	1 120			

NCR:	Yes	/ No				WORK ORDER NON-O	COI	NFOR	MANCE / UPI	DATE			•
											QA Closed:	Date	e: <u> </u>
Work Orde	er: _					DISPOSITION	-			AGAINST DE	EPARTMENT,	_	
Part N	_					Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	-4	Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
						'	J		<u> </u>	' L.		'''	
Root Cause		Date	Step	Qty	1	ption of work order update or Non-conformance	1	Initial nief Eng	Act Descr	ion iption	Sign & Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
						F	AUL	T CATE	GORY				
Landir	E C C C C C C C C C C C C C C C C C C C	ear Bending Centre No Cracks Crushed/C Cuffs Heat Trea Inspection Ripples in	Crimped. t n Strip in Bend	Tube		General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Instruct Mainte Mislabe Misread Offset	on Incomplete ions Incomplete/L nance led	Jnclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned W Power Loss/S	st ssing /rong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Loc Qty Loc Code Location ST100 10 87402 10 ST134 82300 85791

											DQA:	Date:	· <u> </u>
NCR:	Yes	/ No				WORK ORDER NON-	CO	NFORI	MANCE / UP	DATE			>
											QA Closed:	Date	
Work Ord	er.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	•
Part I	- No					Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	otion of work order update		Initial	Act	ion	Sign &		
Cause		Date	Step	Qty	C	or Non-conformance	Ch	nief Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
							AUL	LT CATE	GORY				
Landi		ear Bending				<b>General</b> Bend	_	Grain			Ovalized		Pressure/Forced
	⊢	entre No	it Concer	itric to (	7/5	BOM/Route	-	Hardwa	ro	<u> </u>	Over/Under	tolerance	Temperature/Cure
	H	racks	ic concer			Broken/Damaged		-1	on Incomplete		Part Incorre	_	Weld
	$\Box$	rushed/0	Crimped.			Burrs		4 '	ions Incomplete/l	Jnclear	Part Lost/Mi		Wrong Stock Pulled
		uffs	•			Contamination		Mainte	*		Part Moved		<b>-</b>
	$\prod_{\vdash}$	leat Trea	t			Countersink		Mislabe	led		Positioned V	Vrong	
	$\prod_{i}$	nspection	Strip in	Tube		Cut Too Short		Misreac	I		Power Loss/	Surge	Other
	R	ipples in	Bend		.	Drill Holes		Offset		<del></del>		-	

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID: Parent Item: Parent Item Name:	89123 D350-607-541 Heli-Utility-Basket							Pate: 8/27/12 Qty: 1.00	Required Date: 9/14/12 Required Qty: 1.00
ANAHBA Bolt	nen-ounty-basket	Purchased	No		110	Each	1,115.0000	6 S	6 122808
1				Location	Loc Oty		Loc Code		•
				ST356	500				_
				122416	500				_
				ST357	615				
				120187	19				-
				120770	12				-
				121652	582				-
				122063	2				
NAGIS OLT		Purchased	No		110	Each	29.0000		
				Location	Loc Qty		Loc Code		
				ST358	29				_
				120124	1				_
				121146	28			12/140	
310 <b>C</b> 4		Purchased	No		110	Each	27.0000		1/2200
				Location	Loc Oty		Loc Code		
				ST344	27				_
				120360	1				-
				121166	3				_
				121444	21				
				122151	2				
517984-6413 N, QUICK RELEASE		Purchased	No		110	Each	13.0000		1 122 800 / 12/14
				<b>Location</b>	Loc Oty		Loc Code		
				331	10				_
				122452	10				_
				ST315	3				
				114340	1				-
				118612	2				-

NCR: \	es / No				WORK ORDER NON-	COI	NFORN	ΛANCE / UPI	DATE	QA Closed:	Date:	•
Work Orde					DISPOSITION				AGAINST DE		<u> </u>	•
Part N	lo.				Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update		Initial	Act	ion	Sign &		
Cause	Date	Step	Qty	(	or Non-conformance	Ch	nief Eng	Descr	iption	Date	Verification	QC Inspector
Doc/Data								I				
Equip/Tooling	_							I		:	·	
Operator		Ì						I				
Material							,	I				
Setup								I				
Other								I				
Process	_											
Supplier								1				
Training								j				
Unapproved												
					F	AUL	T CATE	GORY				
Landin	g Gear				General		1		_	7		٦
	Bending				Bend	<u></u>	Grain			Ovalized	<u> </u>	Pressure/Forced
Ĺ	Centre No	ot Concer	ntric to O	/s	BOM/Route		Hardwa	re	_	Over/Under	<del></del>	Temperature/Cure
	Cracks			<u> </u>	Broken/Damaged		1	on Incomplete		Part Incorre	<del>-</del>	Weld
1	Crushed/	Crimped.		<u> </u>	Burrs		4	ions Incomplete/L	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte			Part Moved		
	Heat Trea				Countersink		Mislabe			Positioned V		7
	Inspection	n Strip in	Tube		Cut Too Short		Misread			Power Loss/	Surge	Other
	Ripples in	Bend			Drill Holes		Offset					
	Torque W	aves in E	xtrusion	1	Drawing	1	Out of C	Calibration				

Out of Sequence

Outside Dimensions

Date:

DQA:

Turning Sequence

Wave/Twist in Tube

Finish

August-21-12 2:47:29 PM

, Work Order ID: Parent Item:	89123 D350-607-541								Date: 8/27/12		Required Date: 9/14/12	
Parent Item Name:	Heli-Utility-Basket								Qty: 1.00		Required Qty: 100	
MS2104214		Purchased	No			110	Each	5,025.0000	6	6		
Nut				Location		Loc Qty		Loc Code				
				314		4928	<b>:</b>	200 0000		9		
				314	122452	4928			12246	52		
				ST300		9			<del> </del>			
					121011							
1 )					121444	9:						/
MS24665-151		Purchased	No			110	Each	119.0000		1	122812	
Cotter Pin				Location	(	Loc Qty		Loc Code	· ·			
				ST309		119	)					
				3.00,	17566	119						
NASI5I5H4L SWASHER		Purchased	No			110	Each	375.0000	2	2		2
3 W4 10 M2 M				Location	<u>l</u>	Loc Qty		Loc Code				
				FG			3					
					103691	1	3				1.6	A
				ST277		36	,				•	
					118709	4			1203	286)		
/					120390	363			100=			3
Masher Washer		Purchased	No			110	Each	1,250.0000	12	12	- /42/20/10	5 (C)
-				Location	1	Loc Oty		Loc Code				
				275		600						
					122441	600						
				ST275		650						
					121350	1:			7207	<del>~</del> /		
·					122151	63:	5		1221	51		

NCR:	Yes	/ No				<b>WORK ORDER NON-</b>	CO	NFORM	MANCE / UPD	ATE			د
<b>50.00</b>											QA Closed:	Date	2:
Work Ord	ler:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	•
Part NCR	-					Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update		Initial	Actio	on	Sign &		:
Cause		Date	Step	Qty	(	or Non-conformance	Cł	nief Eng	Descri	ption	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved								LT CATEC	SORV				
Landi	ng G	ear				General		LI CAIL	30111			····································	
		Bending Centre No Cracks Crushed/O Cuffs Heat Trea Inspectior Ripples in	Crimped. t n Strip in i Bend	Tube		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Instructi Mainte Mislabe Misread Offset	on Incomplete ions Incomplete/Ur nance led	nclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	LJ	Torque W	aves in E	xtrusioi	ו [	Drawing		JOut of C	Calibration				

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

August-21-12 2:47:29 PM

Work Order ID:

NAS1149G0463R (

Washer

89123

Parent Item:

D350-607-541

Parent Item Name:

Heli-Utility-Basket

Purchased

No

119097

**Start Date: 8/27/12** 

687.0000

Start Qty: 1.00

Required Qty: 1.00

Required Date: 9/14/12

Loc Code Location Loc Oty FP001 115358 ST297 686 17 117735

669

Each

110

Page 5

											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-O	COI	NFOR	MANCE / UPI	DATE			٥
											QA Closed:	Date:	
Work Ord	lor:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	•
VVOIROIU	. —					Rework	7	•	Skid-tube	Crosstube	7	Water Jet	Engineering
Part	No					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is	1	Ei .	noforming	Finishing	-	re/Packaging	Other
NCR	No.					Work Order Update	1		Large Fab	Composite	1	Supplier	
	_				<del>.</del>						<b>_</b>		
Root					Descri	ption of work order update		Initial	Act	ion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator	Ш												
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Process	Щ												
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	$\vdash$	ending				Bend		Grain		<u> </u>	Ovalized		Pressure/Forced
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	$\vdash$	racks				Broken/Damaged		1 '	on Incomplete		Part Incorre		Weld
	$\vdash$	rushed/C	rimped.			Burrs		4	ions Incomplete/l	Jnclear	Part Lost/M	issing	Wrong Stock Pulled
	$\boldsymbol{\vdash}$	uffs				Contamination	<u></u>	Mainte		<u> </u>	Part Moved		
	H <sub>I</sub>	eat Treat	-			Countersink		Mislabe			Positioned V		7 .
	I IIn	spection	Strip in	Tube		Cut Too Short	1	Misread	i	1	Power Loss/	Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion Turning Sequence Drill Holes

Drawing

Finish

# REFERENCE ONLY

### DART AEROSPACE LTD.



**D350-607-3** Page 17 of 19

### 4.0 WEIGHT AND BALANCE

Installation	Weight	LA	TERAL	LONG	ITUDINAL
		Arm	Moment	Arm	Moment
D350-607-541	80.7 lb	± 49.1 in	± 3962 in-lb	135 in	10895 in-lb
(Standard Basket)	36.6 kg	± 1.25 m	± 45.8 m-kg	3.43 m	125.5 m-kg
D350-607-543	65.7 lb	± 49.1 in	± 3226 in-lb	135 in	8870 in-lb
(Lightweight Basket)	29.8 kg	± 1.25 m	± 37.3 m-kg	3.43 m	102.2 m-kg
D350-607-545	58.7 lb	± 49.1 in	± 2882 in-lb	135 in	7925 in-lb
(Standard Basket)	26.2 kg	± 1.25m	± 32.8 m-kg	3.43 m	89.9 m-kg
D350-607-547	47.7 lb	± 49.1 in	± 2342 in-lb	135 in	6440 in-lb
(Lightweight Basket)	21.6 kg	± 1.25 m	± 27.0 m-kg	3.43 m	74.1 m-kg
D350-607-511 (Quick Release Basket Mounting Kit)	7.2 lb 3.3 kg	± 36.9 in ± 0.94 m	± 266 in-lb ± 3.1 m-kg	135 in 3.43 m	972 in-lb 11.3 m-kg

### 5.0 PARTS LIST

QTY	QTY	QTY	QTY	QTY	QTY	PART NUMBER	DESCRIPTION
-541	-543	-545	-547	-511	-501	FART NUMBER	DESCRIPTION
$\frac{\sqrt{x}}{x}$	-040	-040	-0-7,	7		D350-607-541	HELI-UTILITY-BASKET
<b>-</b>	X					D350-607-543	HELI-UTILITY-BASKET
<b>—</b>		X				D350-607-545	HELI-UTILITY-BASKET
l			X			_D350-607-547	HELI-UTILITY-BASKET
11	1	1		x		_D350-607-511 <sup>3</sup>	QUICK RELEASE BASKET MOUNTING KIT
<u> </u>	<u>-</u>				X	D350-607-501	CONVERSION KIT
7-1	1	1	1	<del></del>	1	D2690-6	LANYARD
				4	4	D3910-3	X-TUBE LUG
1	1	1	1		1	D3912-041	EYEBOLT RECEIVER ASSY
				8	8	D3984-030	RUBBER EXTRUSION, X-TUBE
1						D4030-041	LONG BASKET ASSY
						D4030-043	LONG BASKET ASSY, LIGHTWEIGHT
		1				D4032-041	SHORT BASKET ASSY
			1			-D4032-043	SHORT BASKET ASSY, LIGHTWEIGHT
/1	1	1	1		1_	-D4085-3-	PLACARD-INSTRUCTIONS
1					1	D4086-200	PLACARD, MAX LOAD
	1				1	D4086-215	PLACARD, MAX LOAD
		1			1	D4086-220	PLACARD, MAX LOAD
			1		1	D4086-232	PLACARD, MAX LOAD
				1	1	D4148-041	FWD X-TUBE LUG ASSY
				1	1	D4149-041	AFT X-TUBE LUG ASSY
11	1	1	1		1	D4150-041 2	ATTACHMENT ARM ASSY
1	1	1	1		1	D4151-041 —	-BASKET FWD HARDPOINT ASSY (LOWER)
/ 1	1	1	1			-D4151-043	-BASKET FWD HARDPOINT ASSY (UPPER)
,		6	6		6_	-AN4-13A	BOLT
6	_6			16	6	AN4-14A	BOLT
-				1.0	10	AN4C15	BOLT
41-	1					AN310C4	_CASTELLATED NUT
11	1				1	MS17984-C413	-QUICK RELEASE PIN
7 1	1	1 6	6	16	22	MS21042L4	NUT (OR MS21042-4)
/ 6 /1	6	1	1	10	1 -	MS21042L4	COTTER PIN
					2		ZWASHER
2 2	2	2	2	22	44	NAS1149F0432P	LWASHER
12 ح	12	12	12	32		777	LWASHER
1_3_	3	3 _	3		3	NAS1149C0463R	-WAUCK

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Revision: A

Date: 10.06.28